

Date: Tuesday, 10/02/2009 11:09:04 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	STRUT
<b>Job Number</b> :	45664		
<b>Estimate Number</b> :	11025		
<b>P.O. Number</b> :		<b>Part Number</b> :	D27497
<b>This Issue</b> :	10/02/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2749 REV C
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	26887	<b>Drawing Revision</b> :	C
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	03/03/2009
<b>Written By</b> :		<b>Qty:</b>	6
<b>Checked &amp; Approved By</b> :	JLD 09-02-10	<b>Um:</b>	Each
<b>Comment</b> :	Est:C 00.05.19 Added inspection level 8, removed P/O for powder coating EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0750X00750	6061-T6 Bar .750 x .750
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**Comment:** Qty.: 0.9844 f(s)/Unit Total : 5.9063 f(s)

6061-T6 Bar .75" x .75"

Material: 3/4" x 3/4" bar 6061-T6

Batch: 1108887

SP 09/02/11

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blank: 11.25" long

SP 09/02/11 (6)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2749-7

SP 09/02/11 (6)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SP 09/02/11

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

J.L 09/02/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/02/2009 11:09:04 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 45664

Part Number: D27497

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Tumble and Deburr

N/A 09.02.13

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

09-02-13 (X6)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-02-13 (6)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11 10999 6

START TIME: 2:00pm  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 2:30pm

09-02-13 (X6)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/02/13 (6)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: ST/195

09/02/13 (6)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/2013

Job Completion



MF 09-02-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

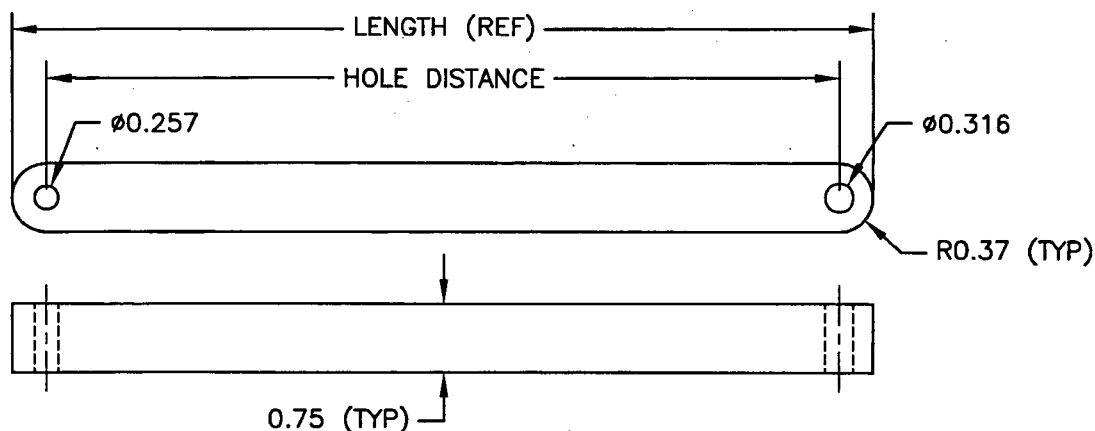




DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2749	REV. C SHEET 1 OF 1
DATE 07.02.13		TITLE STRUT	SCALE NTS
A	99.09.24	NEW ISSUE	
B	99.10.08	REMOVED LIGHTENING HOLES	
C	07.02.13	ADD D2749-9/-11	

RELEASED

07.02.14



DART P/N	HOLE DISTANCE	LENGTH (REF)
D2749-1	8.700	9.45
D2749-3	7.890	8.64
D2749-5	12.630	13.38
D2749-7	10.340	11.09
D2749-9	7.000	7.75
D2749-11	5.188	5.94

**D2749-1/-3/-5/-7/-9/-11 STRUT****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T6512/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART MATERIAL SPEC M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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